

5140

DART AEROSPACE LTD	Work Order:	24093
Description: Hi - Step Leg Assembly	Part Number:	D3065-041
Dwg: D3065 Rev. A1 A2	Qty:	60
RF 03.02.17 RF 03.02.28		Page 1 of 2

6.75
16.88

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller <i>Dwg. not required RF 02.11.04</i> (Minimum lots of 30)	<i>PH</i>	05.08.23	60
2	MV	Cut blanks: 3.600" x 4.500" (grain along 4.500") Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick M17948 (M2024T3S.040) Batch _____ Identify as D3065-1 4.320" RF 02.11.29 4.320"	J.L	05.09.27	60
3	MV	Cut blanks: 6.600" x 4.250" (grain along 4.250" 4.250") RF Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick 02.11.13 (M2024T3S.040) Batch M17948 02.11.29	J.L	05.09.28	60
4	MV	Cut blanks: 4.580" x 4.500" (grain along 4.500") Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch M17948 Identify as D3065-7	J.L	05.09.27	60
5	MV	Cut blanks: 16.61" x 8.51" (grain along 8.51") for each leg. Material: 5052-H32 Sheet (QQ-A-250/8) 0.080" thick (M5052H32S.080) Batch M18388 Identify as D3065-5 (Note: make 2 legs per assembly)	<i>BC</i>	05.09.30	120
	MV	Cut blanks: 16.490" x 0.750" for each spacer. (-0.00/+0.010) Material: 5052-H32 Sheet (QQ-A-250/8) 0.080" thick (M5052H32S.080) Batch M18388 Identify as D3066-1 (Note: make 2 spacers per assembly) M17400 M18710	<i>P</i>	05/10/05	120
7	MV	Machine D3065-1 as per folio FA182 and Dwg D3065, use stack of 15.	J.L	05.10.02	60
8	MV	Deburr to take measurement	J.L	05.10.02	60
9	QC2	Inspect parts as they come off the CNC machine	J.L	05.10.02	60
10	QC8	Second check	<i>En</i>	05/10/02	60
11	MV	Machine D3065-3 as per folio FA180 and Dwg D3065, use stack of 15.	J.L	05.10.02	60
12	MV	Deburr to take measurement	J.L	05.10.02	60
13	QC2	Inspect parts as they come off the CNC machine	J.L	05.10.02	60
14	QC8	Second check	<i>En</i>	05/10/02	60
15	MV	Machine D3065-7 as per folio FA181 and Dwg D3065, use stack of 15.	J.L	05.10.02	60
16	MV	Deburr to take measurement	J.L	05.10.02	60
17	QC2	Inspect parts as they come off the CNC machine	J.L	05.10.02	60
18	QC8	Second check	<i>En</i>	05/10/02	60
19	MV	Machine D3065-5 as per folio FA179 and Dwg D3065, use stack of 10.	/	/	/

15.03.09
#64

RELEASED
02/11/04 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	24093
Description: Hi - Step Leg Assembly	Part Number:	D3065-041
RF 03.02.28		
Dwg: D3065 Rev. A1 A2	Qty:	60
RF 03.02.17		Page 2 of 2

Step	Location	Procedure	By	Date	Qty																								
19	MV	Machine D3065-5 as per folio FA179 and Dwg D3065, use stack of 10.	J.L.	05/10/04	120																								
20	MV	Deburr to take measurement	J.L.	05/10/04	120																								
21	QC2	Inspect parts as they come off the CNC machine	J.L.	05/10/04	120																								
22	QC8	Second check	S.D.	05.10.05	120																								
23	MV	Machine D3066-1 as per Folio FA280 and Dwg D3066, use stack of 10.	J.L.	05/10/05	120																								
24	MV	Deburr to take measurement	J.L.	05/10/05	120																								
25	QC2	Inspect parts as they come off the CNC machine	J.L.	05/10/05	120																								
26	QC8	Second check	E	05/10/06	120																								
27	GA	Deburr D3065-1, D3065-3, D3065-5, D3065-7 & D3066-1 stack.	S.D.	05/10/16	120																								
28	GB	Bend D3065-1, D3065-3 & D3065-7 as per Dwg D3065	S.B.	05/10/26	60																								
29	QC5	Inspect work to Step 28	J	05-10-27	60																								
30	FP	Chemical conversion coat as per QSI 005 4.1 RF 02.11.06 D3065-1, D3065-3, D3065-5, D3065-7 & D3066-1	DL	05/10/27	60																								
31	GA	Assemble as per Dwg D3065 and identify as D3065-041 Assembly. <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3065-1</td><td>Spacer</td><td>B 24093</td></tr><tr><td>1</td><td>D3065-313 22854</td><td>Spacer</td><td>B 24093</td></tr><tr><td>2</td><td>D3065-510 2236C</td><td>Leg</td><td>B 2361811 B 24093</td></tr><tr><td>1</td><td>D3065-7</td><td>Spacer</td><td>B 24093</td></tr><tr><td>30</td><td>MS20470AD4-4</td><td>Rivet (40) 171405</td><td>1760 H17944</td></tr></table>	Qty	Part Number	Description	Batch	1	D3065-1	Spacer	B 24093	1	D3065-313 22854	Spacer	B 24093	2	D3065-510 2236C	Leg	B 2361811 B 24093	1	D3065-7	Spacer	B 24093	30	MS20470AD4-4	Rivet (40) 171405	1760 H17944	S.B.	05/11/08	10
Qty	Part Number	Description	Batch																										
1	D3065-1	Spacer	B 24093																										
1	D3065-313 22854	Spacer	B 24093																										
2	D3065-510 2236C	Leg	B 2361811 B 24093																										
1	D3065-7	Spacer	B 24093																										
30	MS20470AD4-4	Rivet (40) 171405	1760 H17944																										
32	QC5	Inspect work to Step 31	J	05-11-10	10																								
33	GA	Identify and Stock D3065-041 Hi-Step Leg Assembly 339 D3066-1 Spacer Location 338	J	05/11/10	60																								
34	AC	Cost / part 39.86	Sus	05/11/15	60																								
35	DC	Close W/O 40.56 Inspect Level 21	Q	05/11/16	160																								

Rev	Date	Change	Revised By	Approved
A	01.12.10	New Issue	SM	
B	02.09.10	Re-format; Incorporated D3065-1/-3/-5/-7	KJ	
C	02.11.01	Incorporated D3066-1 IPP	KJ RF	

RELEASED
02/11/04 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/11/08	31	2 parts D3065-5 were scrap scratch TO deep 1 parts D3065-3 was scrap	MB 05/11/08	Scrap - 5 <u>DESTROY</u>	MB 05-11-08	MB 05-11-08	MB 05-11-08	MB 05-11-08

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 05/11/16

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

H:\FORMS\Quality Assurance\approved QA\FAI revD

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 18, 2005
10:59 am

Work Order No : 0024093
Project Name : D3065-041
Project For : WK540
Work Order Type : Main
Main WO Number :
House Part Number : D3065-041
Description : Step Leg Assembly
Manufactured : Yes
Amount Req'd : 60
Amount Done : 0
Start Date : 08-17-05
Est Finish Date :
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

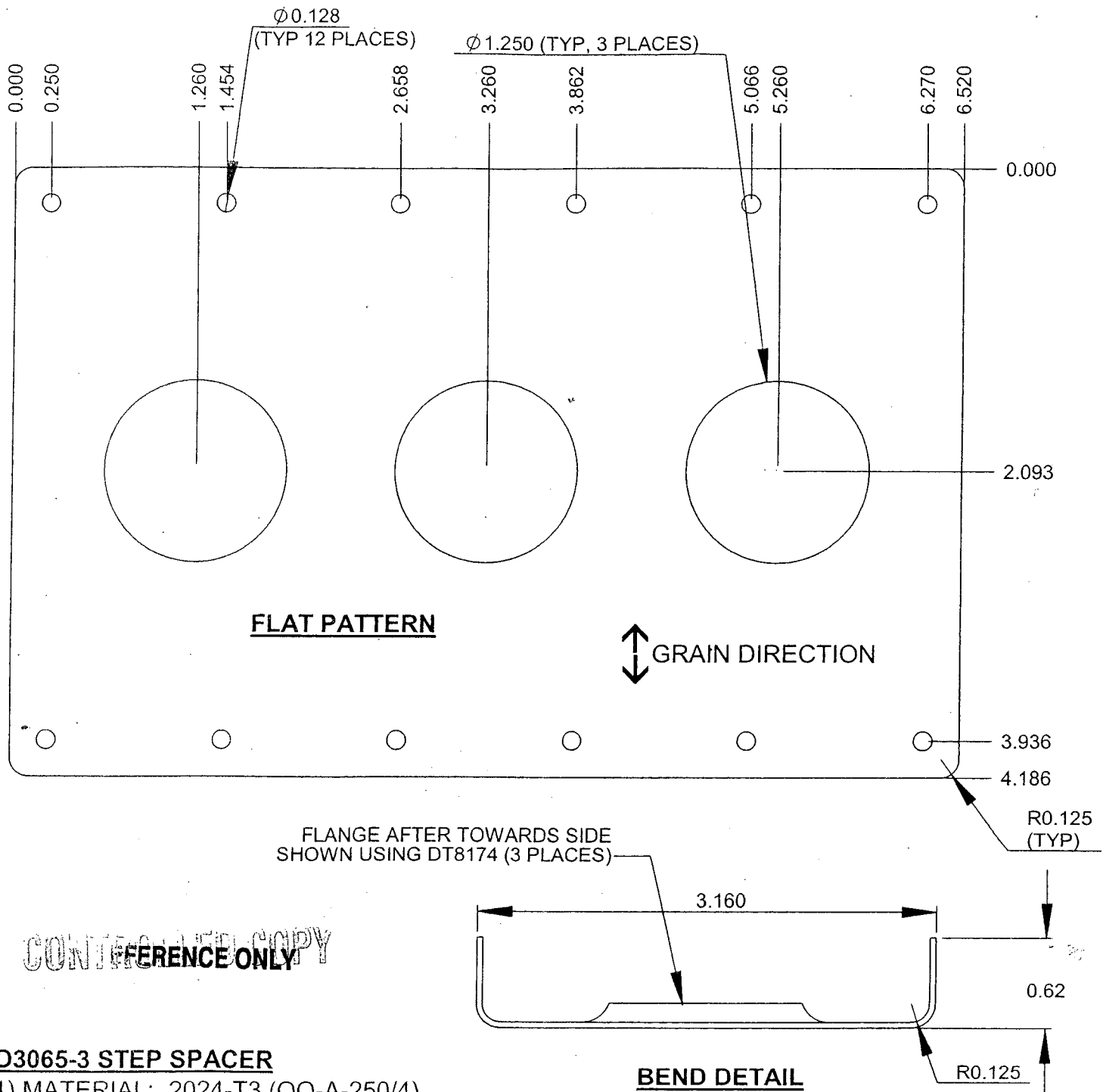
Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D3065	REV. A SHEET 3 OF 5
DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:1



D3065-3 STEP SPACER

- BEND DETAIL**
- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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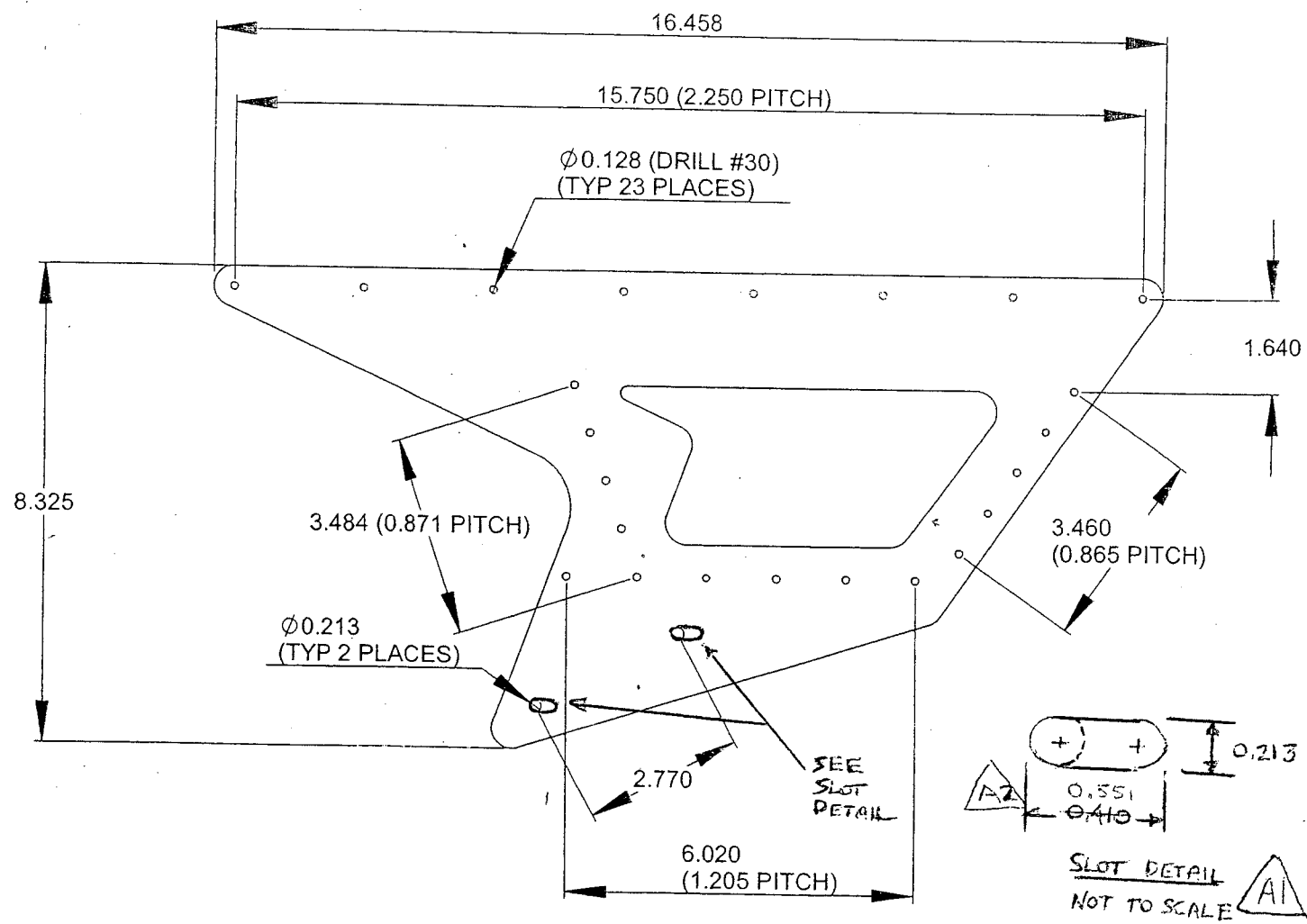
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RELEASED
02.09.20

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DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D3065
DATE	02.09.11	TITLE	STEP LEG ASSEMBLY	REV. A SHEET 4 OF 5
		SCALE	1:3	



D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

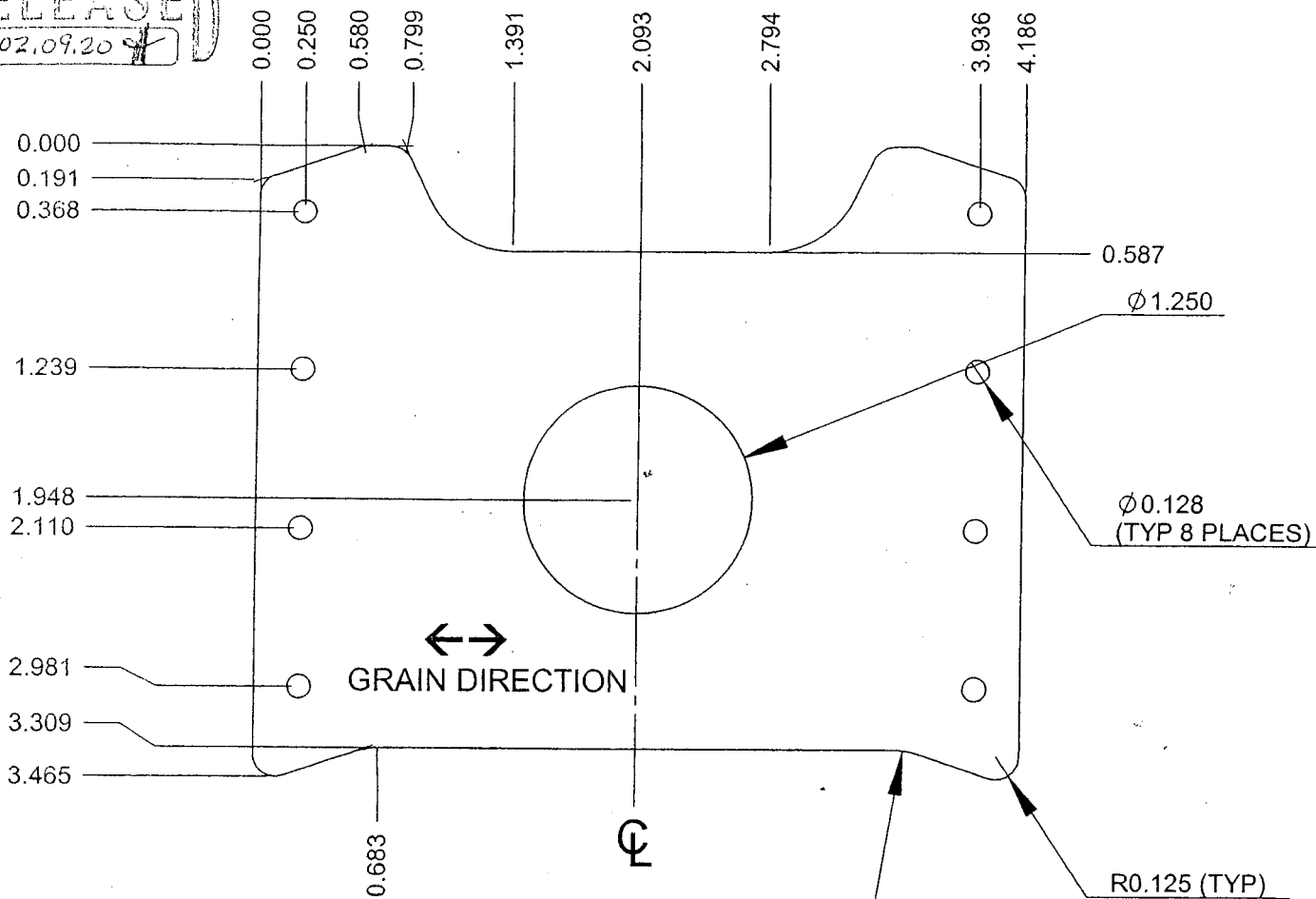
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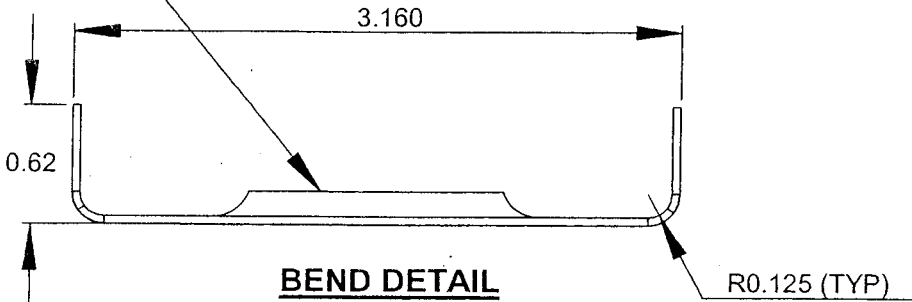
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. A SHEET 2 OF 5
DATE 02.09.11		TITLE STEP LEG ASSEMBLY	
		SCALE 1:1	

RELEASED
02.09.20 *[Signature]*



FLAT PATTERN

FLANGE AFTER BENDING
TOWARDS SIDE SHOWN
USING DT8174
(2 PLACES)



BEND DETAIL

D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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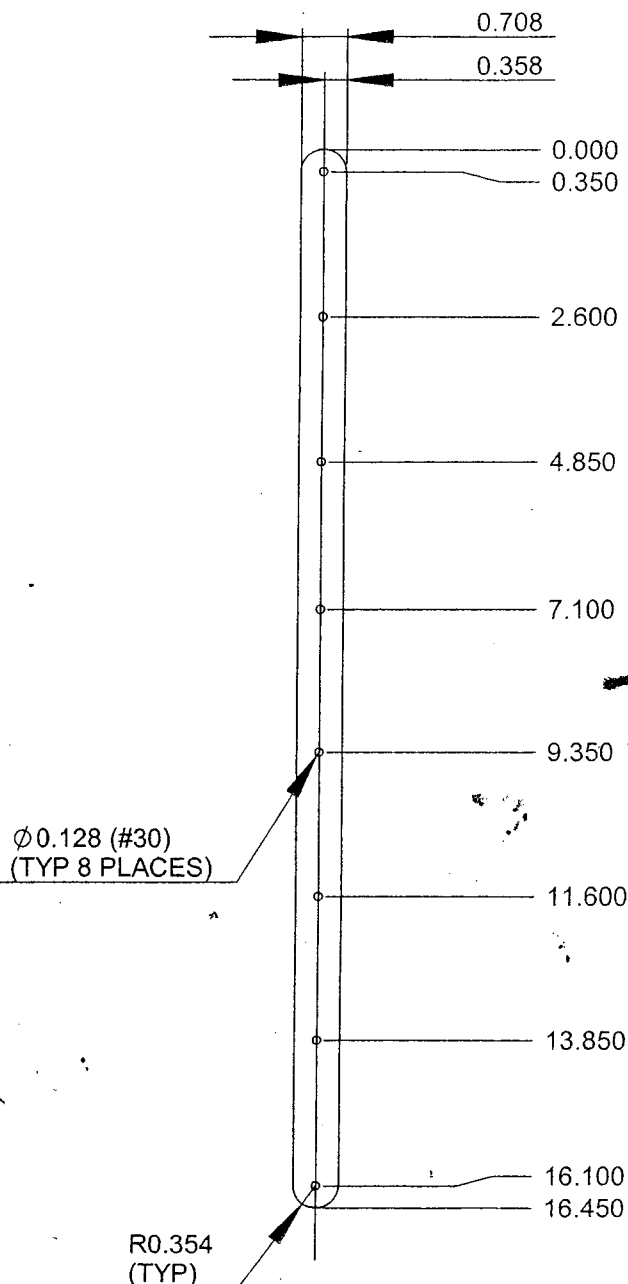


REFERENCE ONLY

COPY ISSUE

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3066	REV. A SHEET 1 OF 1
DATE 02.09.11		TITLE SPACER	SCALE 1:3
A	02.09.11	NEW ISSUE	

RELEASED
02.09.20

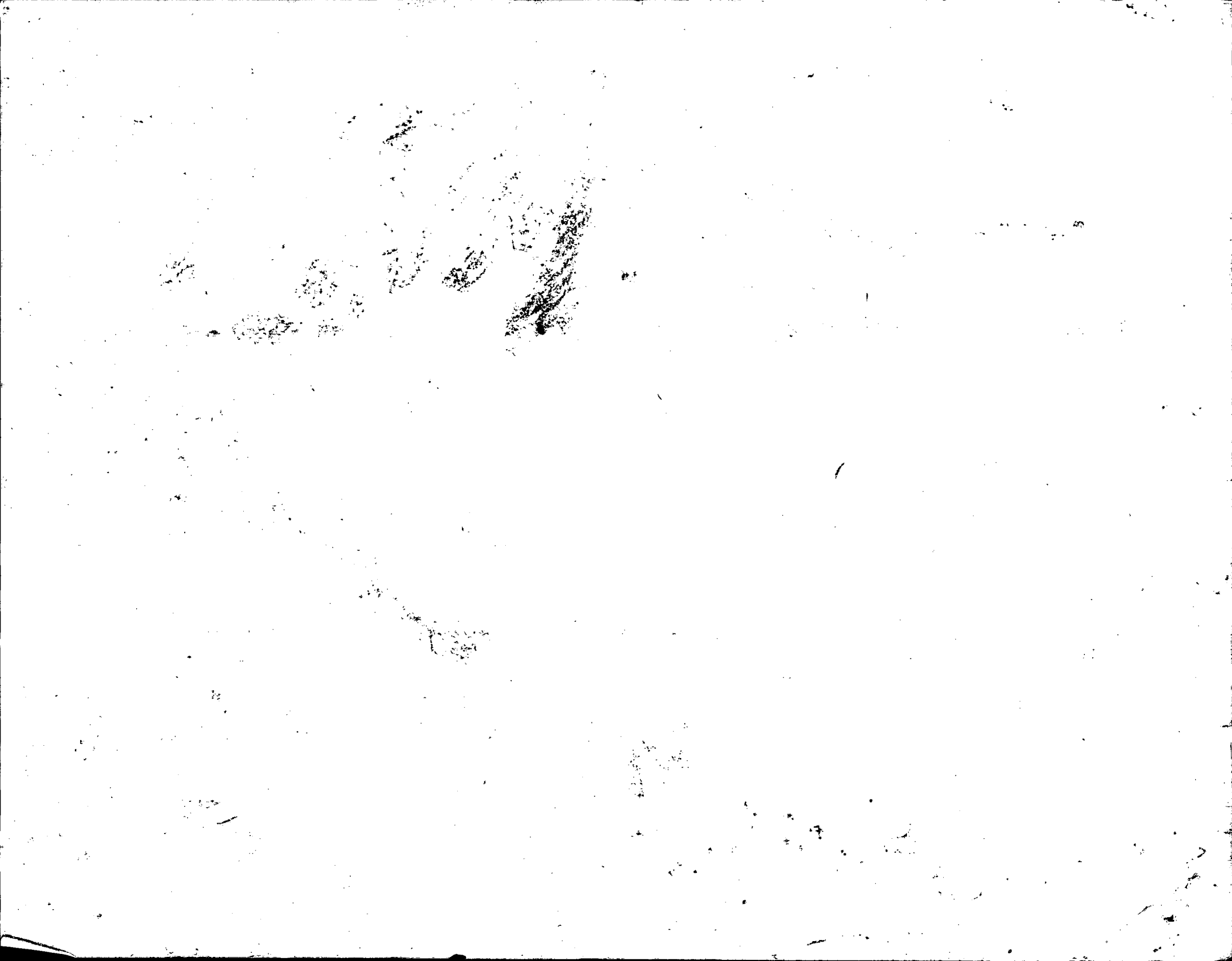


D3066-1 SPACER

- 1) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Date: Friday, 11/11/2005 7:53:54 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	HI-STEP LEG ASSEMBLY	
Job Number :	24093			
Estimate Number :	10385			
P.O. Number :		Part Number :	D3065041	
This Issue :	11/11/2005	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	D3065 REV A2	
First Issue :	/ /	Project Number :		
	Type :	Drawing Revision :	A2	
Previous Run :		Material :		
Written By :		Due Date :	11/18/2005	Qty: 60 Um: Each
Checked & Approved By :				
Comment :	Est Rev: C 02.11.01 Incorporated D3066-1 IPP KJ/RF			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	24093A	STEP SPACER
-----	--------	-------------



Comment: Sub-Component STEP SPACER

2.0	24093B	STEP SPACER
-----	--------	-------------



Comment: Sub-Component STEP SPACER

3.0	24093C	STEP LEG
-----	--------	----------



Comment: Sub-Component STEP LEG

4.0	24093D	STEP SPACER
-----	--------	-------------



Comment: Sub-Component STEP SPACER

5.0	24093E	SPACER
-----	--------	--------



Comment: Sub-Component SPACER

6.0	D30651	Step Spacer
-----	--------	-------------

7.0	D30653	Step Spacer
-----	--------	-------------

8.0	D30655	Step Leg
-----	--------	----------

9.0	D30657	Step Spacer
-----	--------	-------------

10.0	MS20470AD44	Rivet, Universal Head
------	-------------	-----------------------

11.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
------	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3065 and Identify as D3065-041

Date: Friday, 11/11/2005 7:53:54 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 24093

Part Number: D3065041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Date: Friday, 11/11/2005 7:53:57 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	STEP SPACER
Job Number :	24093A		
Estimate Number :	10375		
P.O. Number :		Part Number :	D30651
This Issue :	11/11/2005	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3065 REV. A2
First Issue :	/ /	Project Number :	
Previous Run :		Drawing Revision :	A2
	Type :	Material :	
	SMALL /MED FAB	Due Date :	11/18/2005
Written By :		Qty:	60
Checked & Approved By :		Um:	Each
Comment :	Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M2024T3S040	2024-T3 .040 sheet
-----	-------------	--------------------

2.0	SHEAR	SHEAR
-----	-------	-------

**Comment:** SHEAR

Cut blank: 3.600" x 4.500" Grain along 4.500"

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------

**Comment:** HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA182 and Dwg D3065

Stack of 15

Identify as D3065-1

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

Date: Friday, 11/11/2005 7:53:57 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 24093A

Part Number: D30651

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3065

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Date: Friday, 11/11/2005 7:54:00 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 24093B		
Estimate Number	: 10378		
P.O. Number	:	Part Number	: D30653
This Issue	: 11/11/2005	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3065 REV. A2
First Issue	: / /	Project Number	:
Previous Run	:	Drawing Revision	: A2
	Type : SMALL /MED FAB	Material	:
Written By	: _____	Due Date	: 11/18/2005
Checked & Approved By	: _____	Qty:	60
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M2024T3S040	2024-T3 .040 sheet
-----	-------------	--------------------

2.0	SHEAR	SHEAR
-----	-------	-------



Comment: SHEAR

Cut blank: 6.600" x 4.320" Grain along 4.320"

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA180 and Dwg D3065

Stack of 15

Identify as D3065-3

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

Date: Friday, 11/11/2005 7:54:12 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 24093D

Part Number: D30657

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3065

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Date: Friday, 11/11/2005 7:54:19 AM
User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SPACER	
Job Number :	24093E			
Estimate Number :	10383			
P.O. Number :		Part Number :	D30661	
This Issue :	11/11/2005	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	D3066 REV. A	
First Issue :	/ /	Project Number :		
	Type :	Drawing Revision :	A	
Previous Run :		Material :		
Written By :		Due Date :	11/18/2005	Qty: 120 Um: Each
Checked & Approved By :				
Comment :	Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S080	5052-H32 .080 Sheet
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2.0	SHEAR	SHEAR
-----	-------	-------



Comment: SHEAR

Cut blank: 16.490" x 0.750" -0.000/+0.010"

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA280 and Dwg D3065

Stack of 10

Identify as D3066-1

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

Date: Friday, 11/11/2005 7:54:19 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 24093E

Part Number: D30661

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
10:52 am

Work Order No : 0024093
Project Name : D3065-041
Project For : WK540
Work Order Type : Main
Main WO Number :
House Part Number : D3065-041
Description : Step Leg Assembly
Manufactured : Yes
Amount Req'd : 60
Amount Done : 0
Start Date : 08-17-05
Est Finish Date :
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	86.63	100.00		
Production Cost :	0.00	1605.49	100.00	0.00	1605.49
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	25.62	100.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	1605.49	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	1605.49			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	(-1605.49)

Date: Friday, 11/11/2005 7:54:00 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 24093B

Part Number: D30653

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3065

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Date: Friday, 11/11/2005 7:54:04 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP LEG
Job Number	: 24093C		
Estimate Number	: 10382		
P.O. Number	:	Part Number	: D30655
This Issue	: 11/11/2005	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3065 REV. A2
First Issue	: / /	Project Number	:
Previous Run	:	Drawing Revision	: A2
	Type : SMALL /MED FAB	Material	:
Written By	: _____	Due Date	: 11/18/2005
Checked & Approved By	: _____	Qty:	120
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S080	5052-H32 .080 Sheet
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2.0	SHEAR	SHEAR
-----	-------	-------



Comment: SHEAR

Cut blank: 16.61" x 8.51" Grain along 8.51"

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA179 and Dwg D3065

Stack of 10

Identify as D3065-5

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

Date: Friday, 11/11/2005 7:54:04 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 24093C

Part Number: D30655

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Date: Friday, 11/11/2005 7:54:11 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 24093D		
Estimate Number	: 10380		
P.O. Number	:	Part Number	: D30657
This Issue	: 11/11/2005	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3065 REV. A2
First Issue	: / /	Project Number	:
Previous Run	:	Drawing Revision	: A2
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 11/18/2005
Checked & Approved By	:	Qty:	60
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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2.0	SHEAR	SHEAR
-----	-------	-------



Comment: SHEAR

Cut blank: 4.580" x 4.500" Grain along 4.500"

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA181 and Dwg D3065

Stack of 15

Identify as D3065-7

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack